

Date: Monday, 03/11/2008 10:50:03 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY RH
Job Number :	43145		
Estimate Number :	10268		
P.O. Number :		Part Number :	D350636014
This Issue :	03/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 REV F
First Issue :	03/11/2008	Project Number :	N/A
Previous Run :	43090	Drawing Revision :	F
		Material :	
		Due Date :	15/11/2008
Written By :		Qty:	1
Checked & Approved By :	JLD 08.11.03	Um:	Each
Comment :	Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:I 05.12.08 Rearranged procedure steps EC Est Rev:J 06.03.30 Per rev. D EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-09-23 revF as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 004

S000118

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	42940

2T 08-11-05

3.0	D2744	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 239242 SE 08/11/06

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 7 (D2750-4 details).Drill using drill Jig DT8150 & DT8864 .

 2T
 08-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolt using DT8983. Open to 0.500".

5- locate DT8929 off of blade fitting holes and drill pilot holes for blade fitting.

6-Open up holes for section BE-BE to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail A-B to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail A-A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m/09213 OF 8-11-06*

10-Grind welds flush as per Dwg D2750

11- scribe batch #.

ST 08-11-07

7 JD 8-11-6

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08-11-07 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-07 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-11-8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11 8-11-10

W/O:		WORK ORDER CHANGES					
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Job Number: 43145

Part Number: D350636014

Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B-43163

AUM

8-11-10

1X

10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B43013

BE 8-11-12

11.0	D34905	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B43015

BE 8-11-12

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

B41113

BE 8-11-12

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

exp. date:

B-P9449
5-11-30

AUM
5-11-10

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

5L8-119

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

(welding instructions on sheet 11)

A/R Aluminum Rod batch: *M 109813 BE 08-11-12*

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

-AHM 5-11-12

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08-11-12

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-12

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/11/13

17.0

POWDER COATING

POWDER COATING



M109152



(1X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*3:20
320°F
3:50*

M-L 08/11/13

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-11-17

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: *M 100621*

94

08-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B41114

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B42982

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B42479

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B42927

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B42480

08-11-17

W/O:		WORK ORDER CHANGES					
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Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 D37943 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: 13413116

JU

27.0 D353525 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 13482926

JU

28.0 D353625 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 13412980

JU

29.0 D35371 Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

WEARPAD

Batch: 13412820

JU

30.0 D36311 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: 1341141

JU

31.0 D3488042 Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, RH

Batch: 1342415

JU

32.0 NAS1611010 O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

O-RING

NAS1611-010 batch:

(or MS28775-010) batch: M101029

JU

08-11-17

W/O:		WORK ORDER CHANGES					
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Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1611005

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
O-RING
batch: _____

~1/4 this one #. fine only 6/11/17

34.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 1342936 *JH*

35.0

D3492045

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 1342478 *JH*

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)
Bolt
Batch: M109545 *JH*

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: M108880 *JH*

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
BOLT
Batch: M109765 *JH*

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
BOLT
Batch: M1106896 *JH* 08.11.17 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

washer

Batch: M109752

JU

41.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: M109632

JU

42.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M109758

JU

43.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M109740

JU

44.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: (2x) M104291 (2x) M105728

JU

45.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

sikaflex batch: M109449 WTN

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M1107912

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M109449

JU 08-11-17 OK

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

EXP DATE: 08/11

5-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M101223

6-Coat all exposed fasteners with "LPS Procyon" batch: M1104251

HP 08-11-17 (X)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Scanned 9/17/17

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: B422222 B422222

SP

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M109632

SP

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M109840

SP

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M109772

8/11/17

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 43145

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit-- Total : 2.0000 Each(s)

WASHER

Batch: M108964

SP

53.0

D34931

Washer



(K)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B40829

8/11/17

SP

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Soduko @

55.0

PACKAGING 1

PACKAGING RESOURCE #1



(K)

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

loc 72

Rev G

8/11/18

SP

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/19

MK 08-11-18

Job Completion



343145

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

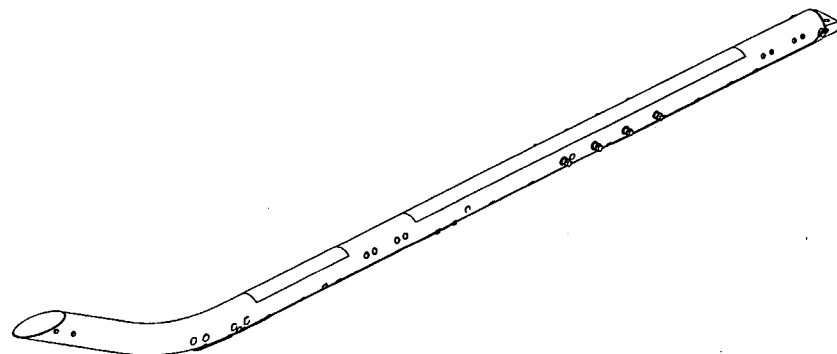
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2-/3-/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT-ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

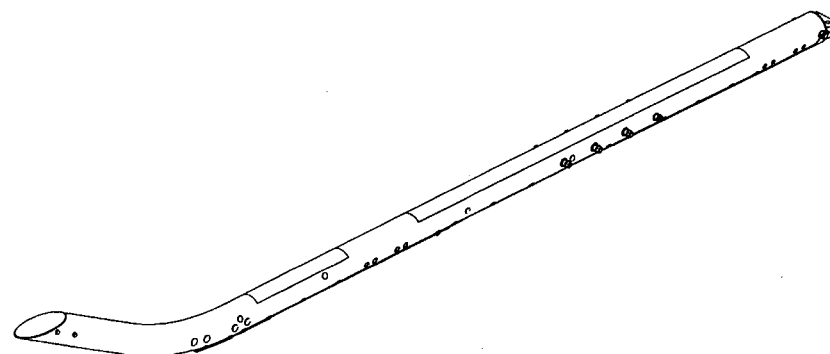
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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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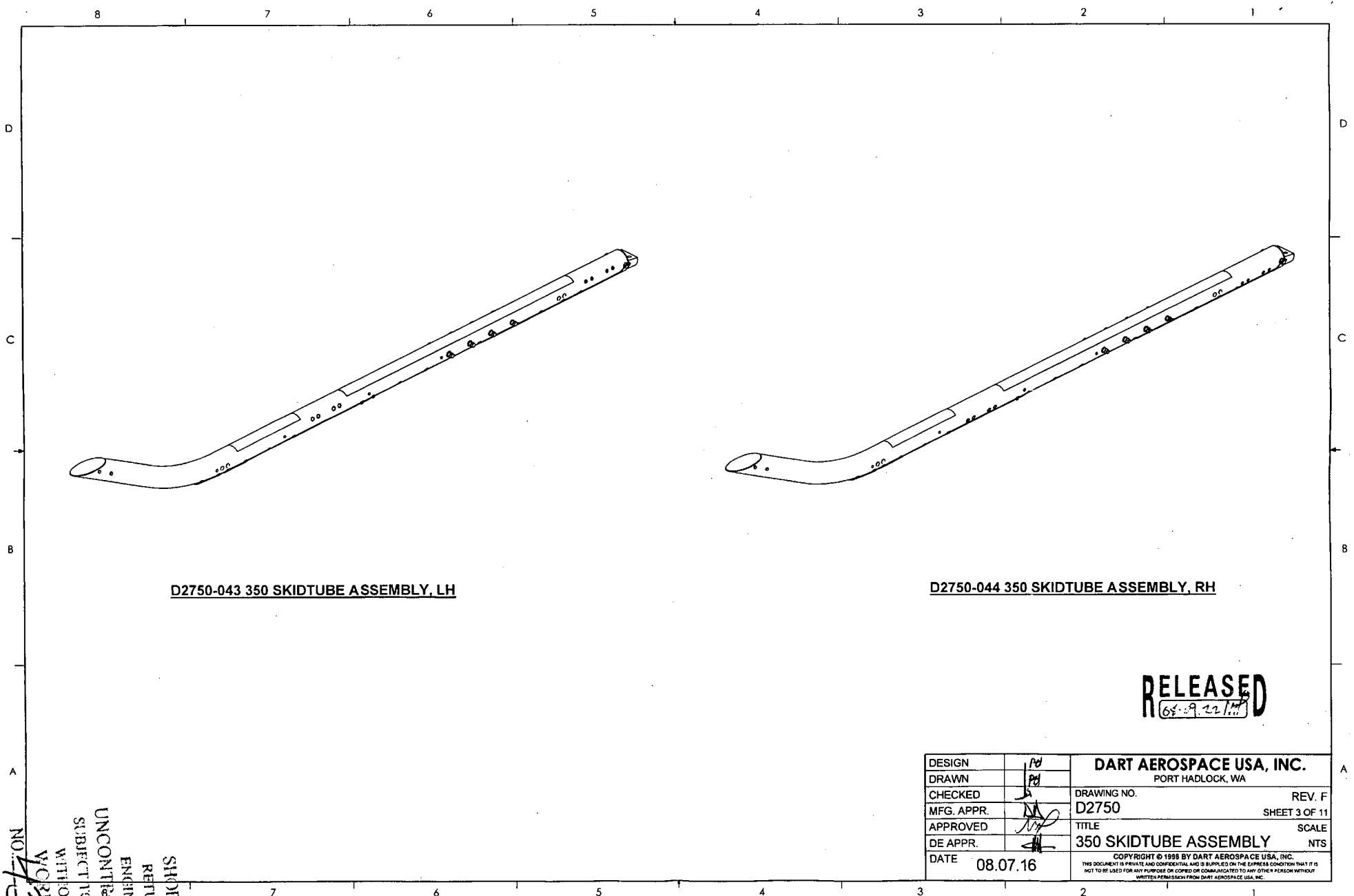


D2750-042 350 SKIDTUBE ASSEMBLY, RH

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D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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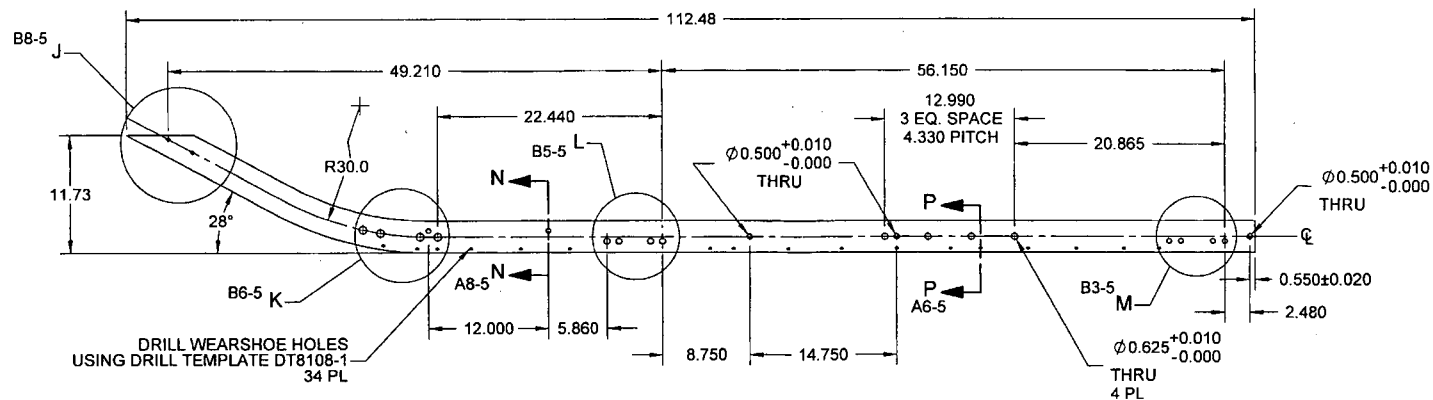
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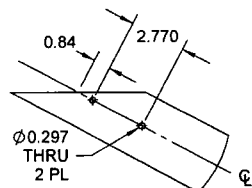
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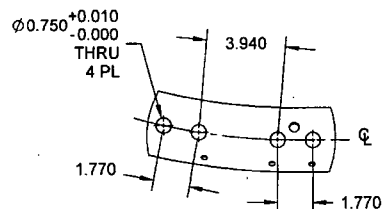
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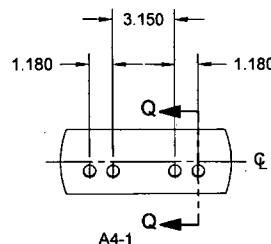
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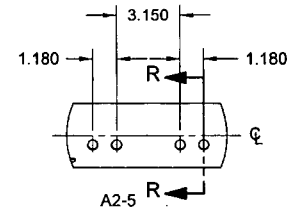
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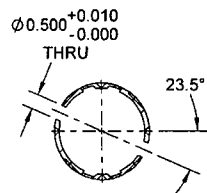
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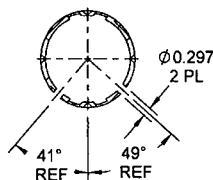
DETAIL L
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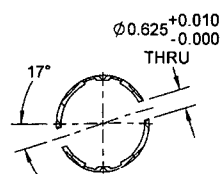
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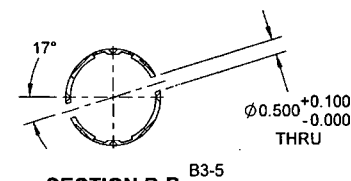
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



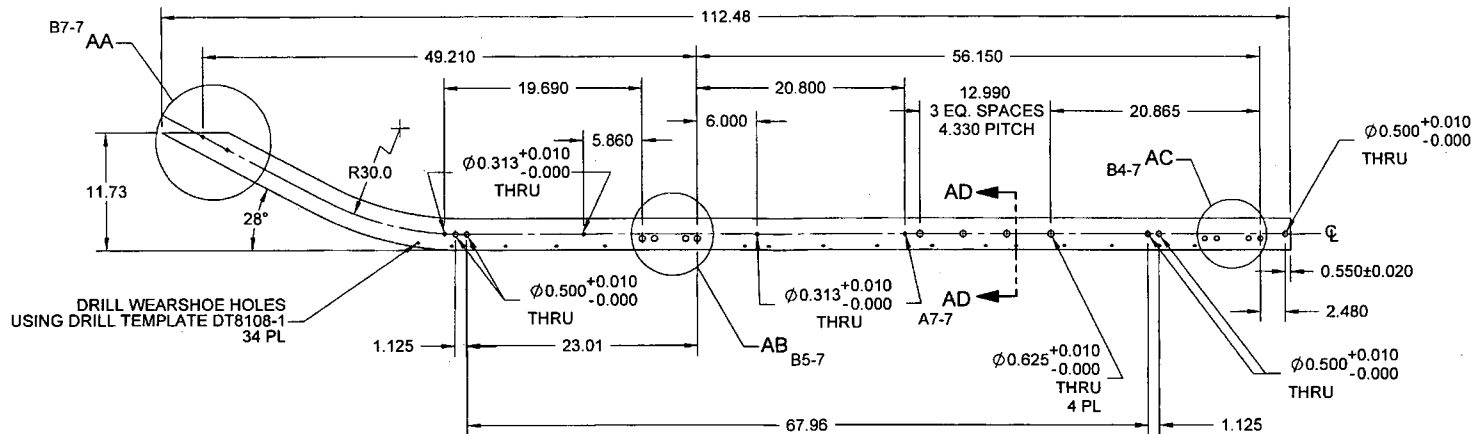
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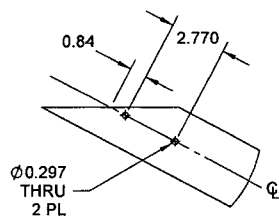
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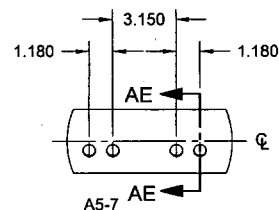
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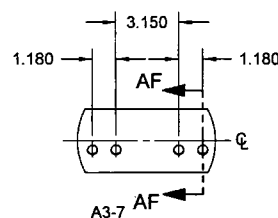
D2750-4 RH SKIDTUBE



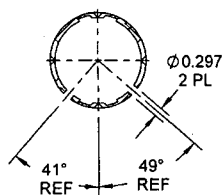
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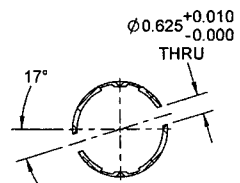
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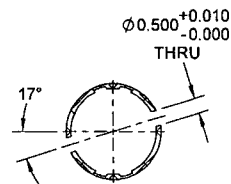
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



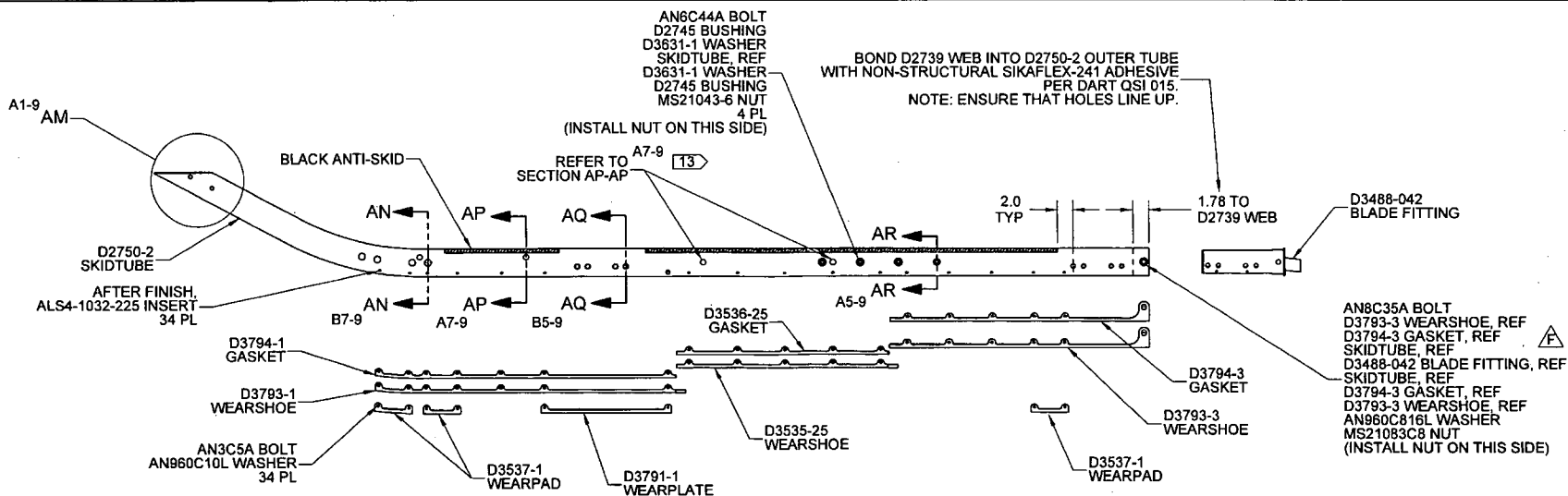
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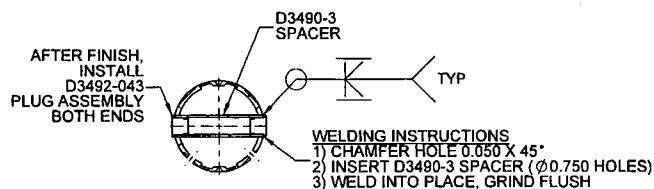
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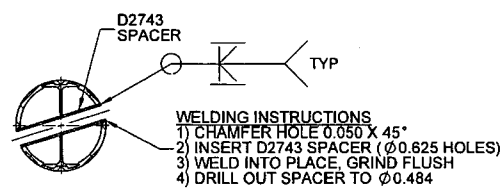
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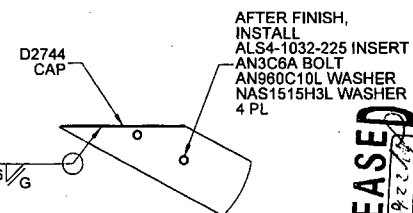
D2750-042 350 SKIDTUBE ASSEMBLY, RH



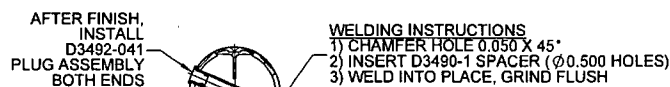
SECTION AN-AN
SCALE 3X, 4 PL



SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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A1-10

AS

BLACK ANTI-SKID

REFER TO
SECTION AW-AWD2750-3
SKIDTUBEAFTER FINISH,
ALS4-1032-225 INSERT
34 PLD3794-1
GASKETD3793-1
WEARSHOEAN3C5A BOLT
AN960C10L WASHER
34 PLD3537-1
WEARPADD3791-1
WEARPLATEAN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL BOLT ON THIS SIDE)

AT

AU

AV

2.0
TYP1.78 TO
D2739 WEBD3488-041
BLADE FITTINGBOND D2739 WEB INTO D2750-3 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)**D2750-043 350 SKIDTUBE ASSEMBLY, LH**D2743
SPACER

TYP

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484**SECTION AT-AT**
SCALE 3X, 4 PL

D6-10

WELDING INSTRUCTIONS1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)D2743
SPACER

TYP

SECTION AV-AVSCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

D4-10

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PLD2744
CAP1/16
G**DETAIL AS**
SCALE 2X

D8-10

RELEASED
08.07.16AFTER FINISH,
INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDSD3490-5
SPACERWELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH**SECTION AU-AU**
SCALE 3X, 4 PL

D5-10, D6-10

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDSD3490-1
SPACERWELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

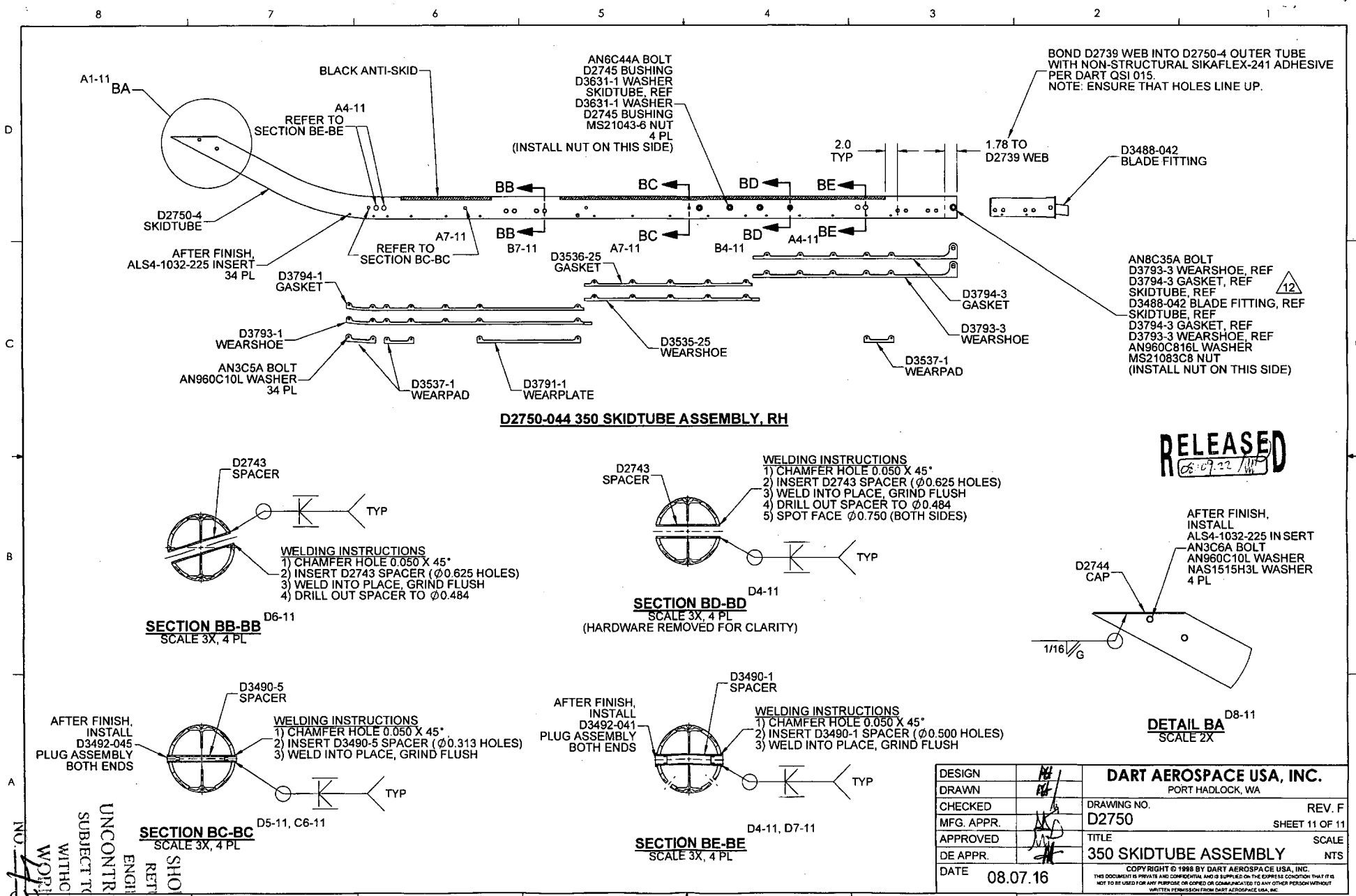
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SECTION AW-AW
SCALE 3X, 4 PL

D4-10, D7-10

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